Interzinc® 72

Epoxy Zinc-Rich

PRODUCT DESCRIPTION

A two component, metallic zinc rich epoxy primer, designed to provide excellent corrosion resistance both as a single coat and as a primer for a high performance coating system. Contains 90% zinc by weight in the dry film.

INTENDED USES

As a factory or site applied primer, for use in high performance coating systems for the protection of steel in aggressive environments such as offshore structures, refineries, petrochemical and chemical plants, power stations, bridges and pulp and paper plants.

PRACTICAL INFORMATION FOR INTERZINC 72

Colour	Grey
Gloss Level	Matt
Volume Solids	60%
Typical Thickness	50-75 microns (2-3 mils) dry equivalent to 83-125 microns (3.3-5 mils) wet
Theoretical Coverage	8 m²/litre at 75 microns d.f.t and stated volume solids 321 sq.ft/US gallon at 3 mils d.f.t and stated volume solids
Practical Coverage	Allow appropriate loss factors
Method of Application	Airless Spray, Air Spray, Brush, Roller

Drying Time

			Overcoating Interval with recommended topcoats	
Temperature	**Touch Dry**	**Hard Dry**	*Minimum*	*Maximum*
10°C (50°F)	45 minutes	6 hours	8 hours	Extended[1]
15°C (59°F)	35 minutes	4 hours	6 hours	Extended[1]
25°C (77°F)	25 minutes	90 minutes	4 hours	Extended[1]
40°C (104°F)	20 minutes	45 minutes	2 hours	Extended[1]

[1] See International Protective Coatings Definitions and Abbreviations

REGULATORY DATA

Flash Point (Typical)	Part A 32°C (90°F); Part B 33°C (91°F); Mixed 32°C (90°F)	
Product Weight	2.77 kg/l (23.1 lb/gal)	
VOC	149 g/kg	EU Solvent Emissions Directive (Council Directive 2010/75/EU)

Coating hazard marker GB 30981.2-S-Pb≤1000-NC Qualified for GB 30981.2-2025

See Product Characteristics section for further details

SURFACE PREPARATION

All surfaces to be coated should be clean, dry and free from contamination. Prior to paint application all surfaces should be assessed and treated in accordance with ISO 8504-1.

Oil or grease should be removed in accordance with SSPC-SP1 solvent cleaning.

Abrasive Blast Cleaning

Abrasive blast clean to Sa2½ (ISO 8501-1:2007) or SSPC-SP6. If oxidation has occurred between blasting and application of Interzinc 72, the surface should be reblasted to the specified visual standard.

Surface defects revealed by the blast cleaning process should be ground, filled, or treated in the appropriate manner.

A surface profile of 40-75 microns (1.5-3.0 mils) is recommended.

Shop Primed Steel

Interzinc 72 is suitable for application to unweathered steelwork freshly coated with zinc silicate shop primers.

If the zinc shop primer shows extensive or widely scattered breakdown, or excessive zinc corrosion products, overall sweep blasting will be necessary. Other types of shop primer are not suitable for overcoating and will require complete removal by abrasive blast cleaning.

Weld seams and damaged areas should be blast cleaned to Sa2½ (ISO 8501-1:2007) or SSPC-SP6.

APPLICATION

Mixing

Material is supplied in two containers as a unit. Always mix a complete unit in the proportions supplied. Once the unit has been mixed it must be used within the working pot life specified.

(1) Agitate Base (Part A) with a power agitator.

(2) Combine entire contents of Curing Agent (Part B) with Base (Part A) and mix thoroughly with power agitator.

Mix Ratio

4.0 part(s) : 1.0 part(s) by volume

Working Pot Life

10°C (50°F)	15°C (59°F)	25°C (77°F)	40°C (104°F)
12 hours	10 hours	8 hours	5 hours

Airless Spray	Recommended	Tip Range 0.43-0.53 mm (17-21 thou) Total output fluid pressure at spray tip not less than 176 kg/cm² (2503 p.s.i.)	
Air Spray (Pressure Pot)	Thinning may be required.	Gun Air Cap Fluid Tip	DeVilbiss MBC or JGA 704 or 765 E
Brush	Suitable - small areas only	Typically 40-50 microns (1.6-2.0 mils) can be achieved	
Roller	Suitable - small areas only	Typically 40-50 microns (1.6-2.0 mils) can be achieved	
Thinner	International GTA220	Do not thin more than allowed by local environmental legislation	
Cleaner	International GTA822		

Work Stoppages

Do not allow material to remain in hoses, gun or spray equipment. Thoroughly flush all equipment with International GTA822. Once units of paint have been mixed they should not be resealed and it is advised that after prolonged stoppages work recommences with freshly mixed units.

Clean Up

Clean all equipment immediately after use with International GTA822. It is good working practice to periodically flush out spray equipment during the course of the working day. Frequency of cleaning will depend upon amount sprayed, temperature and elapsed time, including any delays.

All surplus materials and empty containers should be disposed of in accordance with approrpriate regional regulations/legislation.

PRODUCT CHARACTERISTICS

In order to ensure good anti-corrosive performance, it is important to achieve a minimum system dry thickness of 40 microns (1,5 mils). To achieve a uniform film at this thickness thinning at around 10% with International thinners will be required.

When applying Interzinc 72 by brush or roller, it may be necessary to apply multiple coats to achieve the total specified system dry film thickness.

Surface temperature must always be a minimum of 3°C (5°F) above dew point.

This product will not cure adequately below 5°C (41°F). For maximum performance ambient curing temperatures should be above 10°C (50°F).

Where Interzinc 72 is to be used as a primer for a coating system to be subjected to water immersion, it is important to ensure that a minimum dry film thickness of 65 microns (2,5 mils) is applied in order to provide adequate corrosion protection.

Over-application of Interzinc 72 will extend both the minimum overcoating periods and handling times, and may be detrimental to long term overcoating properties.

Excessive film thickness may lead to splitting of the film when overcoated with high build systems.

In the event of Interzinc 72 being allowed to weather before being topcoated, it is important to ensure that all zinc salts are removed prior to paint application, and recommended topcoats are applied.

Interzinc 72 is not suitable for exposure in acid or alkaline environments.

This product has the following specification approvals:
- BS5493 (1977) : DF & KP1B
- BS4652:1995
- British Gas Specification PA9 and PA10

Note: VOC values are typical and are provided for guidance purpose only. These may be subject to variation depending on factors such as differences in colour and normal manufacturing tolerances.

SYSTEMS COMPATIBILITY

Interzinc 72 can be overcoated with a wide range of high performance topcoats including:

Intercure 200	Intergard 411
Intercure 420	Intergard 475HS
Intercure 422	Interseal 670HS
Intergard 251	Intersheen 73
Intergard 269	Intertuf 708
Intergard 400	Interzone 505
Intergard 405	Interzone 954
Intergard 410	

For other suitable primers/topcoats consult International Protective Coatings.

ADDITIONAL INFORMATION

Further information regarding industry standards, terms and abbreviations used in this data sheet can be found in the following documents available at www.international-pc.com:

- Definitions & Abbreviations
- Surface Preparation
- Paint Application
- Theoretical & Practical Coverage

Individual copies of these information sections are available upon request.

SAFETY PRECAUTIONS

This product is intended for use only by professional applicators in industrial situations in accordance with the advice given on this sheet, the Safety Data Sheet and the container(s), and should not be used without reference to the Safety Data Sheet (SDS).

All work involving the application and use of this product should be performed in compliance with all relevant national, Health, Safety & Environmental standards and regulations.

In the event welding or flame cutting is performed on metal coated with this product, dust and fumes will be emitted which will require the use of appropriate personal protective equipment and adequate local exhaust ventilation.

If in doubt regarding the suitability of use of this product, consult AkzoNobel for further advice.

PACK SIZE	Unit Size	Part A		Part B	
		Vol	Pack	Vol	Pack
	10 litre	8 litre	10 litre	2 litre	2.5 litre
	For availability of other pack sizes, contact AkzoNobel.				

SHIPPING WEIGHT (TYPICAL)	Unit Size	Part A	Part B
	10 litre	27.3 kg	2.1 kg

STORAGE		
	Shelf Life	12 months (Part A) and 18 months (Part B) minimum at 25°C (77°F). Subject to re-inspection thereafter. Store in dry, shaded conditions away from sources of heat and ignition.

Important Note

The information in this data sheet is not intended to be exhaustive; any person using the product for any purpose other than that specifically recommended in this data sheet without first obtaining written confirmation from us as to the suitability of the product for the intended purpose does so at their own risk. All advice given or statements made about the product (whether in this data sheet or otherwise) is correct to the best of our knowledge but we have no control over the quality or the condition of the substrate or the many factors affecting the use and application of the product. Therefore, unless we specifically agree in writing to do so, we do not accept any liability at all for the performance of the product or for (subject to the maximum extent permitted by law) any loss or damage arising out of the use of the product. We hereby disclaim any warranties or representations, express or implied, by operation of law or otherwise, including, without limitation, any implied warranty of merchantability or fitness for a particular purpose. All products supplied and technical advice given are subject to our Conditions of Sale. You should request a copy of this document and review it carefully. The information contained in this data sheet is liable to modification from time to time in the light of experience and our policy of continuous development. It is the user's responsibility to check with their local representative that this data sheet is current prior to using the product.

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